

8/21/19



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBE332A94-3400-03-5**Job Sheet 199373****Part No:** RBE332A94-3400-03-5**Job Qty:** 3 pcs**Part Name:** Sight Support**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 8/21/19**Job Tracking No:****Due Date:** 11/22/19**Created By:** Marie Lajeunesse**Type:** SOLD**Description:****Note:** DWG RBE332A94-3400-03 Rev A IPP Rev. A 19.02.19 New issue DP Verify DD**Ship Via:**

Materials
Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S233157**Part:** RBE332A94-3400-03-5**Job No:** 199373**Serial No/Batch:** S233157

Revision: A
Inspector:
Exp Date:
Instructions:

Date: 11/18/19

Job Routing								
Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier Lead Time	
100	Small Fab - 1	3 pcs	11/22/19	0.00	0.60		Small Fab - 1 Small Fab - 2 Small Fab - 3 Small Fab - 4 Small Fab - 5 Small Fab - 6 Small Fab - 7 Small Fab - 8	MLL
110	QC 5	3 pcs	11/22/19	0.00	0.00		QC 5 - 10 QC 5 - 12 QC 5 - 17 QC 5 - 18 QC 5 - 19 QC 5 - 22 QC 5 - 24 QC 5 - 3 QC 5 - 43 QC 5 - 49 QC 5 - 51 QC 5 - 58 QC 5 - 68 QC 5 - 9 QC 5 - 50 QC 5 - 30 QC 5 - 40 QC 5 - 61 QC 5 - 81	DAS 40 9-89 NOV 7 1 2019
120	Packaging 3-1 - Stock - B4B	3 pcs	11/22/19	0.00	0.00		Packaging 3 - 1 - B4B Packaging 3 - 2 - B4B Packaging 3 - 3 - B4B Packaging 3 - 4 - B4B Packaging 3 - 5 - B4B Packaging 3 - 6 - B4B Packaging 3 - 7 - B4B Packaging 3 - 8 - B4B Packaging 3 - 9 - B4B Packaging 3 - 10 - B4B	DAS 28 9-89
130	QC 21 - SA	3 pcs	11/22/19	0.00	0.00		QC 21 - SA - 21 QC 21 - SA - 70 QC 21 - SA - 53	DAS 21 5-89 NOV 25 2019

Part Op 100 - Assemble as per DWG. See note 8 and 9.
 Descriptions: 110 - QC5- Inspect part completeness to step on W/O
 120 - The tool must be packaged with a desiccant bag into a tight fitting sealed plastic bag as per DWG.
 130 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
65 90591A171	Hex Nut	9 Ea (3 ea)	100-Small Fab - 1	FM138414-8
69 91090A112	Zinc-Plated Steel Large-Diameter Flat Washer 3/8" Screw	9 Ea (3 ea)	100-Small Fab - 1	5157263
70 91280A636	Hex Head Cap Screw	9 Ea (3 ea)	100-Small Fab - 1	50471000
58 96445K251	Steel Belleville Disc Spring 10.2mm ID. X 1.1mm THK.	36 Ea (12 ea)	100-Small Fab - 1	5157243
40 98023A031	Yellow Zinc Plated Grade 8 Steel Washer 0.406" ID. X 0.812" OD. X 0.051"-0.080" THK.	9 Ea (3 ea)	100-Small Fab - 1	5232916
1408 RBE332A94-3400-03-6	Sight Support Weldment	3 pcs (1 ea)	100-Small Fab - 1	5224029

Job Allocations

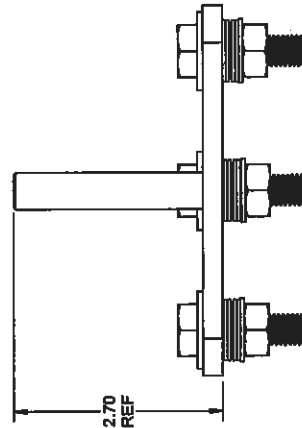
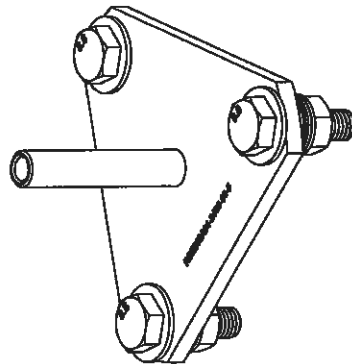
Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	90591A171	9	64	0
	91090A112	9	44	0
	91280A636	9	49	0
	96445K251	36	48	0
	98023A031	9	64	0
	RBE332A94-3400-03-6	3	0	0

Part Specifications

Specifications could not be found.

Plex 8/21/19 8:04 AM Dart.lajeunesse.marie

ITEM #	QTY	PART #	PART TITLE
-6	1	RBE332A94-3400-03-6	SIGHT SUPPORT WELDMENT
29	3	McMaster#91090A112 OR EQUIV.	ZINC PLATED STEEL WASHER 0.406" ID. X 1.000" OD. X 0.066"-0.071" THK.
30	3	McMaster#91280A638 OR EQUIV.	ZINC PLATED CLASS 8.8 STEEL HEX HEAD SCREW M10 X 1.5 mm X 35 mm LG.
31	3	McMaster#90591A171 OR EQUIV.	ZINC PLATED CLASS 8 STEEL HEX NUT M10 X 1.5 mm X 8 mm HT.
32	12	McMaster#96445K251 OR EQUIV.	STEEL BELLEVILLE DISC SPRINGS 10.2 mm ID. X 1.1 mm THK.
33	3	McMaster#96023A031 OR EQUIV.	YELLOW ZINC PLATED GRADE 8 STEEL WASHER 0.406" ID. X 0.812" OD. X 0.051"-0.080" THK.



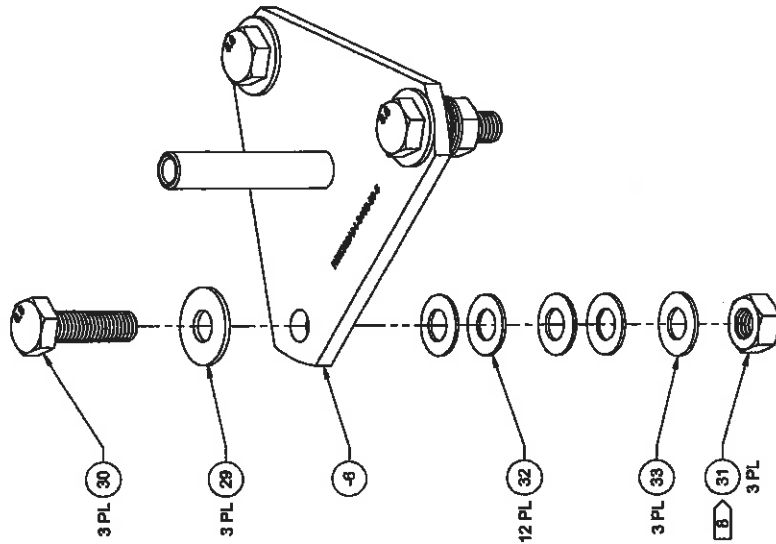
RBE332A94-3400-03-5 SIGHT SUPPORT

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
NO. 199373 HCS
19-08-21

NOTES:

- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = $\pm 0.1"$ / $\pm 1"$
X.XX = $\pm 0.01"$ / $\pm 0.5"$
X.XXX = $\pm 0.005"$ / $\pm 0.1"$
X.XXXX = $\pm 0.0005"$ / $\pm 0.05"$
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = $\pm 0.005"$
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) IDENTIFICATION: N/A
- 7) ASSEMBLY AS SHOWN
- 8) INSTALL ITEM 31 HAND TIGHT
- 9) THE TOOL ASSY MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG



DESIGN DRAWN	KPT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	KPT	TOOL PART #
MFG. APPR.	MBB	RBE332A94-3400-03
APPROVED	DP	TITLE
DATE 2/14/2019	VH	T/R DRIVE ALIGNMENT INSPECTION
		SCALE NTS
		REV. A
		SHEET 8 OF 28
		NTS

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only

NCR No. _____

Job: _____

Part No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐

DEPARTMENT/PROCESS

Cross tube ☐
Small Fab ☐
Finishing ☐
Skid-tube ☐
Machining ☐
Large Fab ☐
Eng. (Non-AW) ☐
Prod. Eng. Coord. ☐
Rec/Store/Packaging ☐
Engineering ☐
Water Jet ☐
Supplier ☐
Quality ☐

Date: _____ Sequence #: _____

QTY Affected: _____

MRB (QSI042)

Description Work Order Deviation

Disposition

Completed By _____

Lead hand / Supervisor _____

QC / QA Coordinator _____

Root Cause

Operator ☐
Manufacturing Process ☐
Equip/Tooling ☐
Handling/Preservation ☐
Material ☐
Product Improvement ☐
Process Improvement ☐
Human Factors ☐

FAULT CATEGORY

Pressure/Forced	Contamination	Power Loss/Surge	Positioned Wrong
Bending	Misaligned/off center	Folio/Program	Outside Tolerance
Crushing	BOM/Route	Grain Direction	Drawing
Cracks	Broken/Damage/Defect	Weld	Finish
Crimp/Kink/Ripple/Wave/Twist	Incomplete/Unclear Instructions	Wrong Stock Pulled	Part Lost/Missing
Marks/Chatter	Drill Holes	Out of Sequence	Misread
Mislabeled	Fit/Function	Off-set/Set-up	

Other/Details: _____